

Product Information

Plasticlear – 421-40XX

PRODUCT DESCRIPTION

421-4020	Low Gloss
421-4035	Satin Gloss
421-4050	Semi-Gloss
421-4090	Full Gloss

Plasticlear is a high quality, acid curing Reactive Amino Coating (RAC). This is a fast building product due to its very high solid content (59% volume). Plasticlear is a low VOC product with 3.32 lb/gal VOC's. It contains a UV block giving Plasticlear light stable properties. This product is recommended for kitchen cabinets, office or residential furniture as well as other interior wood applications where high build and durability are desired.

FEATURES

Plasticlear 421-40XX provides a smooth, knock-proof and hardwearing surface resisting influence from alcohol, water, household products, and marring.

Plasticlear has very good light stability based on resin choice and the addition of a U.V. inhibitor.

Special Recognition: Meets Kitchen Cabinet Manufacturer Association (KCMA) Standards.
Recommended: American Woodworking Institute (AWI). T.R.4.

Note: Plasticlear must not be polluted with oil, varnish or the like and must not be sanded with steel wool between the coats. Plasticlear must not be used and dried at temperatures below 64°F or relative humidity above 65%. During the curing process, the coating must not be exposed to ammonia vapors. Ammonia cleaners should not be used for cleaning the finished surface. This may accelerate discoloration.

SPECIFICATION VALUES

Gloss:	As required
Flash Point:	15°C (58°F)
Specific Gravity:	1.01
Weight per Gallon:	8.45
Solids by Weight:	65%
Solids by Volume:	59%
Fire Hazard Class:	3
Health Hazard Class:	2
Viscosity at 25°C (77°F):	58" z#2
VOC:	385 g/l (3.2 lb/gal)
Lbs. VOC/Gallon:	3.32 lb/gal
Lbs. VOC/Lbs. Solids:	0.69
Lbs. VHAPs/Lbs. Solids:	<0.12

Values at Application if Catalyzed:(25% reduction)

Lbs. VHAPs/Lbs. Solids:	<0.12
Lbs. VOC/Lbs. Solids:	1.05

If additional reducers or additives are used, compliance values must be recalculated.

SPECIFICATION INFORMATION

Shelf Life: Twelve months recommended if unopened and stored between 15°C - 25°C (59°F - 77°F). Always rotate stock.

Pot Life: Mix only enough for one days use for optimum product performance. Use of material, which has been catalyzed for more than 12 hours, may cause failure in film integrity.

Coverage: Coverage is 946 sq. ft/gal at 1 mil dry and at 100% transfer efficiency. Coverage will vary depending on method of application or coating thickness.

Mixing Ratio: 10 parts volume of Plasticlear 421-40XX: 1 part by volume of 873-0870 Catalyst.

Reduction: Use Reducer 803-1325 for hot climates and extra flow. Use Chemcraft® Retarder 800-5328 to slow the cure and keep the film open longer.

Sealers: This product can be used as a self-sealer if reduced 20-30%. It can also be sealed using Catalyzed Vinyl Sealer 546-7003 or Danseal (Catalyzed) 432-1220. Consult with your coatings supplier for specific recommendations.

DIRECTIONS FOR USE

Surface Preparation: Substrate must be sanded using 120 or 150 grit stearted paper prior to staining or coating. Sealers, if used, should be sanded prior to being coated with 240, 280 and 320 grit stearted paper. The substrate as well as the sealers should be topcoated within eight hours of being sanded. Appropriate sealers are Catalyzed Vinyl Sealer 546-7003 with 3% Catalyst 873-0870, or self-seal. Plasticlear cannot be used on metal, old oil or cellulose lacquers. Stain systems used under acid catalyzed systems should be acid stable. Chemcraft recommends using 825-70XX Easywipe stains or 891-73XX N.G.R. stains.

Directions for Use: Catalyze and reduce the material as recommended. Plasticlear is applied in one to three coats on all kinds of wood meant for indoor use. On open pored woods, the best self-sealing is obtained by adding a minimum of 25% Reducer 803-1325 to the Plasticlear after catalyzing. Thorough sanding between the coats is a must for good adhesion. The second and subsequent coats must be applied the same day as the previous coat is sanded.

Plasticlear must be thoroughly stirred, while adding catalyst and reducer in the recommended ratio. Total recommended film build of Plasticlear and sealer should not exceed 4 mils dry.

Contact with metal surfaces should be avoided once the Plasticlear has been catalyzed. To ensure proper sheen, the catalyzed material should be agitated at all times.

The customer is responsible for following the recommended application procedures. Failure to adhere to the recommendations given in this technical data sheet will likely result in unsatisfactory film appearance or film failure. The completed coating system should be checked for required properties prior to start-up of production.

APPLICATION

Method of Application:	Viscosity	Wet Film	Dry Film
Spray - Conventional	Z #2/20-22"	3-4 mils	1.2-1.6 mils
- Airless	Z #2/22-25"	3-4 mils	1.2-1.6 mils
- HVLP	Z #2/17-20"	3-4 mils	1.2-1.6 mils

All measurements recommended are based on results at temperatures of 68°F. Viscosity will vary depending on the temperature of the liquid.

Drying Times:

At 68°F	(Minimum Required)	At 122°F	(Minimum Required)
Tack Free:	15 minutes	Tack Free:	Flash off before entering oven
Dry to Sand:	2 hours	Dry to Sand:	45 minutes
Dry to Stack:	Overnight	Dry to Stack:	3 hours

Note: Dry times are greatly affected by film build, porosity of substrate, air movement as well as heat and humidity. Temperatures are based on actual board temperature. This may vary depending on length of time for boards to reach these temperatures. Minimum curing temperatures of 64°F/18°C must be maintained throughout the curing cycle to achieve the film integrity as stated in product features.

Clean-Up: Use 803-1298.